

D119-796-241 XTUBE ASSY (AW119 MKII AFT)

NOTES:

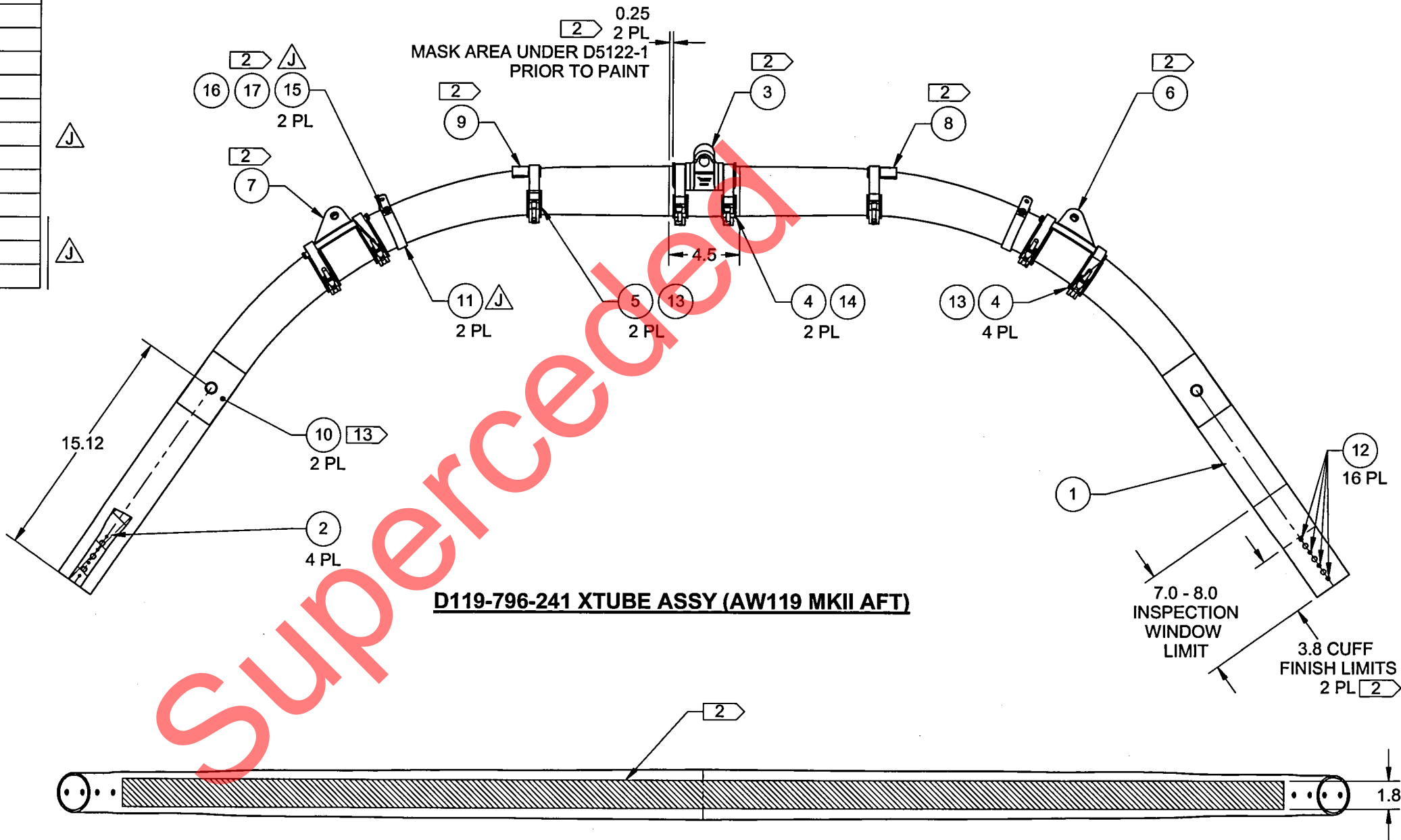
- 1) MATERIAL: N/A
- 2) FINISH: MASK D5134-041/-042 DAMPER SUPPORT ASSEMBLIES, CUFFS, D5136-1/-2 CONTACT PADS, THE COMPLETE CIRCUMFERENCE OF THE TUBE UNDER THE D5122-1 CENTER SUPPORT AND THE TAB ON THE D5515-1 GROUNDING CLAMP PRIOR TO APPLICATION OF CLEAR COAT/PAINT. IF NECESSARY TOUCH UP PRIMER ON OUTSIDE OF CROSSTUBE PER DART QSI 005 4.2. APPLY MATTE CLEAR COAT TO THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA) PER QSI 005 4.2. MASK THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA). PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-241" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 26.26 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) INSTALL D5122-1 CENTER SUPPORT HAND TIGHT ONLY. DO NOT TORQUE. INSTALL RED TAG TO INDICATE "D5122-1 CENTER SUPPORT MUST BE BONDED PER IIN-D119-796 PRIOR TO FLIGHT".
- 10) PRIOR TO FINISHING, ABRASE MATING SURFACES OF D5136-1/-2 AND SURFACE OF CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5136-1/-2 CONTACT PADS AND INSTALL AT AN 8.4" OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL MS21920-25 CLAMPS AND D5123-5 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 11) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY, THE NUT HAS NOT BOTTOMED-OUT AFTER TORQUING AND THE NUT IS FACING AFT.
- 12) PRIOR TO FINISHING, POSITION AND INSTALL D5134-041/-042 DAMPER SUPPORTS USING JIG DT10085. ABRASE MATING SURFACES OF THE D5134-041/-042 DAMPER SUPPORTS AND CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5134-041/-042. INSTALL MS21920-25 CLAMPS AND D5123-1 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS. ENSURE THAT THE MS21920 CLAMPS ARE POSITIONED AS SHOWN IN DETAIL C.
- 13) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE AND D5152-043 WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. INSTALL D5152-043 WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE, 0.100" MIN THK LOCATE D5152-043 USING TOOL DT10112.
- 14) INSTALL THE D5515-1 GROUNDING CLAMP AND ASSOCIATED HARDWARE PER DETAIL "C" PRIOR TO FINISHING. TORQUE THE MS21042-3 NUT 12-15 IN-LB. COMPLETELY SEAL THE EDGES OF THE CLAMP USING PROSEAL 890.
- 15) CARRY OUT A RESISTANCE CHECK BETWEEN THE D5515-1 GROUNDING CLAMP AND ANY UNPAINTED SECTION OF THE CROSSTUBE IN ACCORDANCE WITH AC43-13-1B CHAPTER 11. MAXIMUM RESISTANCE IS 3 MILLIOHMS.

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| J | ADD NOTE 14 & 15 ON SHT 1, ADD PAINT/PRIMER MASKING LOCATIONS, REVISE NOTES ON SHT 1 & 4, REVISE BOM ON SHT 2 TO ADD GROUNDING CLAMP AND ASSOCIATED HARDWARE. REF PAR 17-580 | ML | 17.02.10 |
| I | D6023-106 MATERIAL REPLACES D6009-106. D5136-1/-2 & D5134-041/-042 NOW INSTALLED ON PRIMER. | AP | 15.10.13 |
| H | NOTE 9 RE-WRITTEN. BONDING INSTRUCTIONS MOVED TO IIN. SEE PREVIOUS REV FOR DETAILS. | AP | 15.07.02 |
| G | FINISHING ORDER ADJUSTED, UPDATE BEND TOLERANCE AND TRN DETAIL TOLERANCE TO MATCH D119-796-141 DWG | AP | 15.04.24 |
| F | REMOVED PRIMER/PAINT ON CUFFS, 2.516 WAS 2.500 (C8-5) | AP | 15.02.03 |
| E | D5152-043 WAS D5150-3, SCOTCH BRITE 7447 RED WAS 180 GRIT SANDPAPER | DB | 15.01.15 |
| D | ADD D5150-3 STEP POST (2X). MOVED INSPECTION WINDOW DETAIL TO SHT 1, MODIFIED NOTES ON SH 1& 3 | DB | 14.11.25 |
| C | CR3212-4-07 RIVETS WAS CR3212-4-05 RIVETS, RADIUS BLOCK WAS NUT PLATE ASSEMBLY (BOM), REMOVED 7.5 DEG CUFF HOLE OFFSET (A1-3), REDUCED CUFF DIA TO 2.500 (C8-5), ADD INSPECTION WINDOW | AP | 14.10.23 |
| B | ORIENTATION OF D5122-1 CENTER SUPPORT WAS CORRECTED. D5123-5 ADDED UNDER D5136-1/-2 CONTACT PADS. ADDED D2873-043 NUT PLATE ASSY & CR3212-4-05 RIVETS. ADDED REFERENCE TO SKIDTUBES FOR LOCATING CUFF HOLES. RE-ORGANIZED NOTES, REMOVED REDUNDANT INFORMATION. | AP | 14.09.08 |
| A | NEW ISSUE | AP | 14.08.07 |
| REV. | DESCRIPTION | BY | DATE |
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| DRAWN | ML | | |
| CHECKED | JMH | DRAWING NO. | REV. J |
| MFG. APPR. | DP | D119-796-241 | SHEET 1 OF 7 |
| APPROVED | WM | TITLE | SCALE |
| DE APPR. | DS | XTUBE ASSY (AW119 MKII AFT) | NTS |
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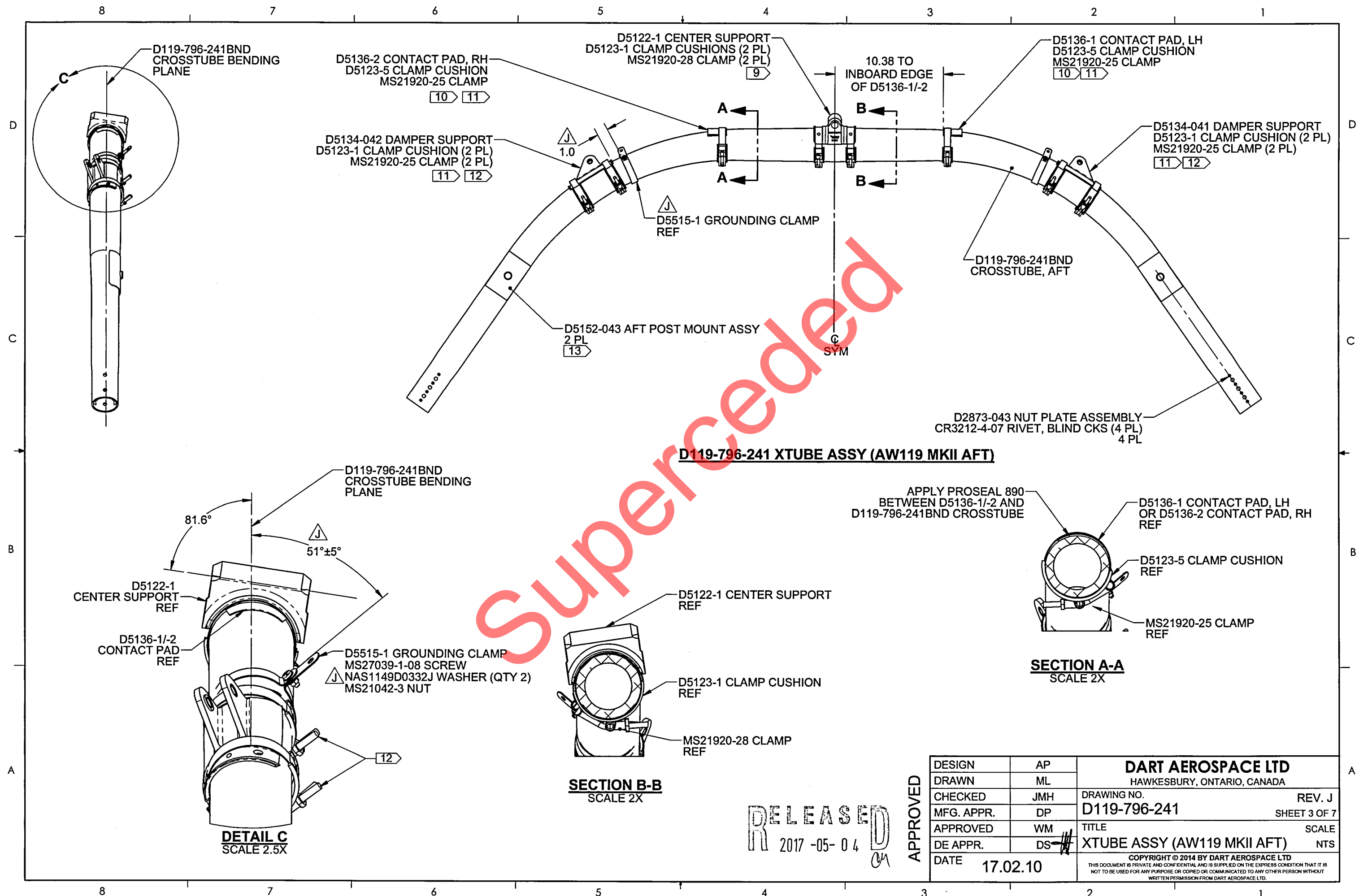
| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------------|-----------------------------|
| | X | D119-796-241 | XTUBE ASSY (AW119 MKII AFT) |
| 1 | 1 | D119-796-241BND | CROSSTUBE, AFT |
| 2 | 4 | D2873-043 | RADIUS BLOCK |
| 3 | 1 | D5122-1 | CENTER SUPPORT |
| 4 | 6 | D5123-1 | CLAMP CUSHION |
| 5 | 2 | D5123-5 | CLAMP CUSHION |
| 6 | 1 | D5134-041 | DAMPER SUPPORT ASSY, LH |
| 7 | 1 | D5134-042 | DAMPER SUPPORT ASSY, RH |
| 8 | 1 | D5136-1 | CONTACT PAD, LH |
| 9 | 1 | D5136-2 | CONTACT PAD, RH |
| 10 | 2 | D5152-043 | AFT POST MOUNT ASSY |
| 11 | 2 | D5515-1 | GROUNDING CLAMP |
| 12 | 16 | CR3212-4-07 | CSK RIVET, CHERRY MAX |
| 13 | 6 | MS21920-25 | CLAMP |
| 14 | 2 | MS21920-28 | CLAMP |
| 15 | 2 | MS27039-1-08 | SCREW, PAN-HEAD |
| 16 | 2 | MS21042-3 | NUT |
| 17 | 4 | NAS1149D0332J | WASHER |



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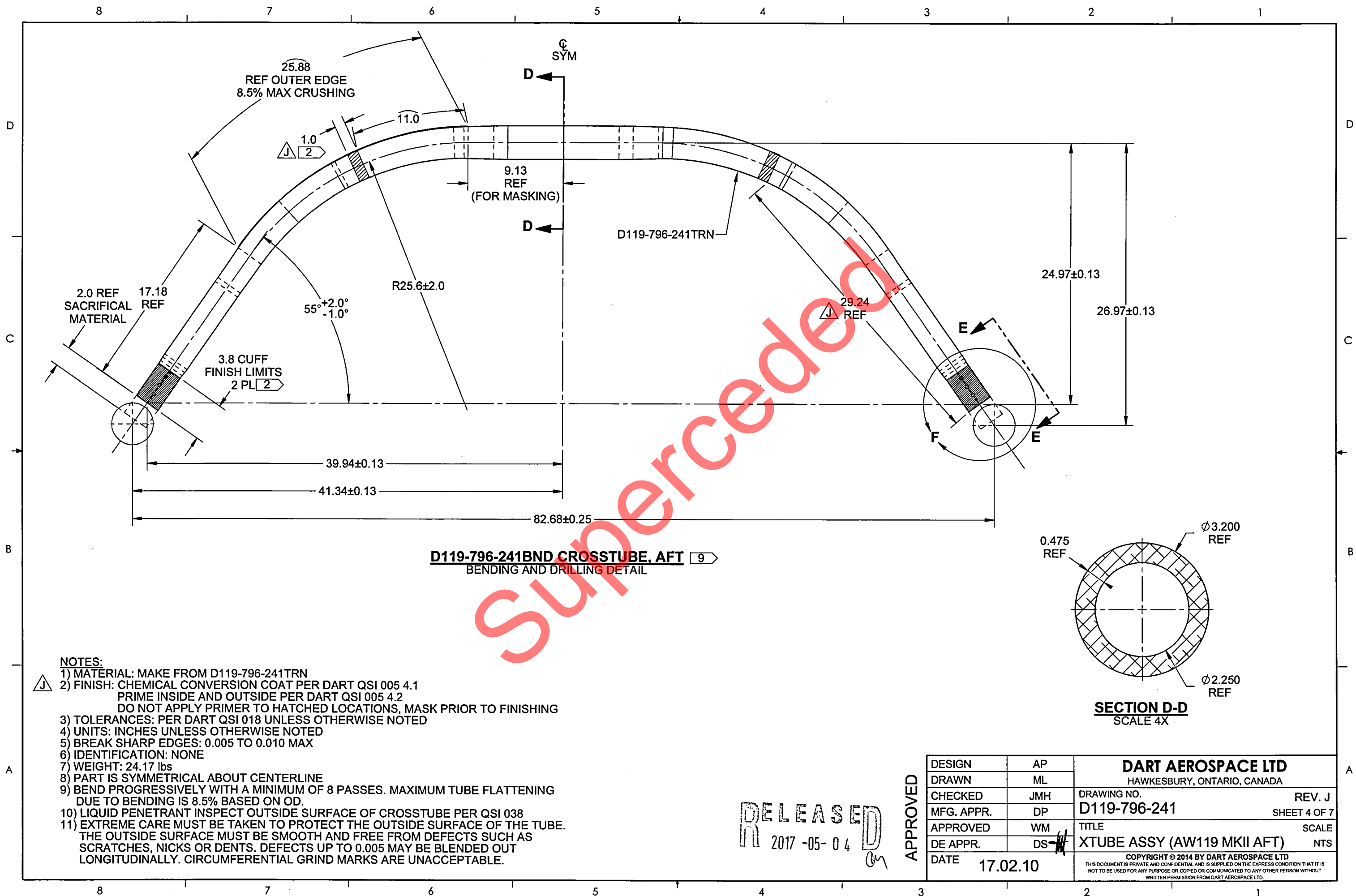
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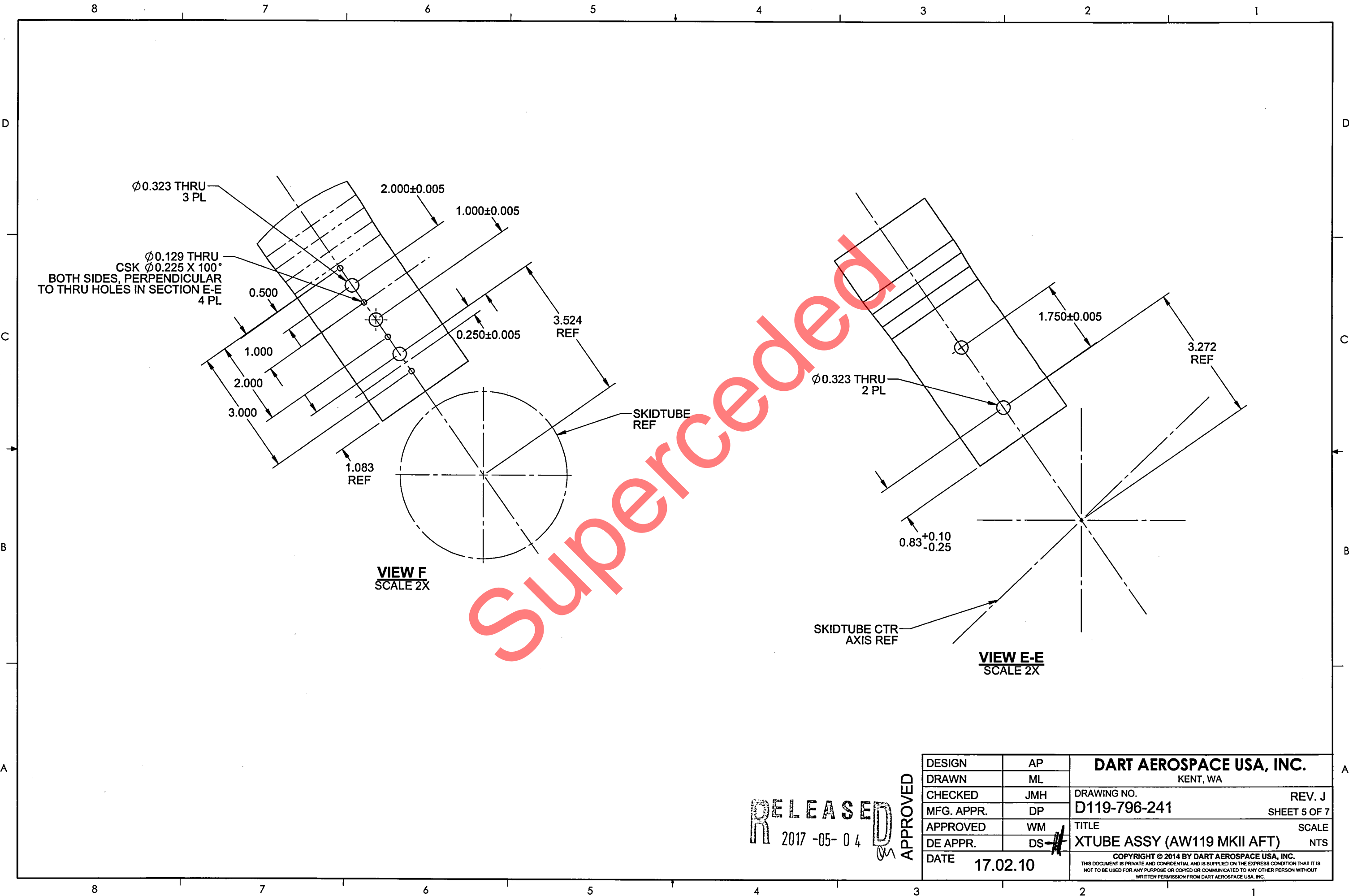


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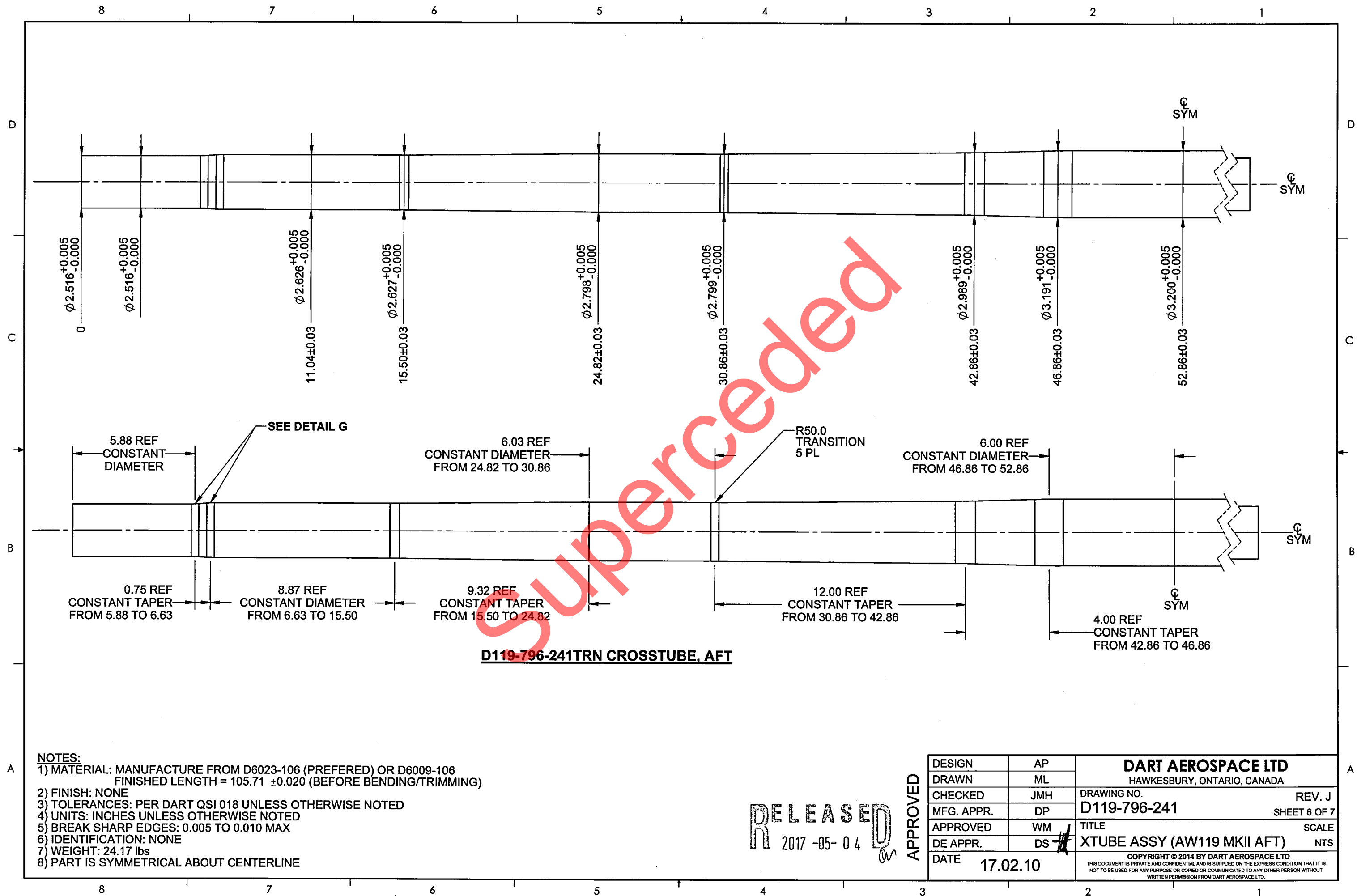




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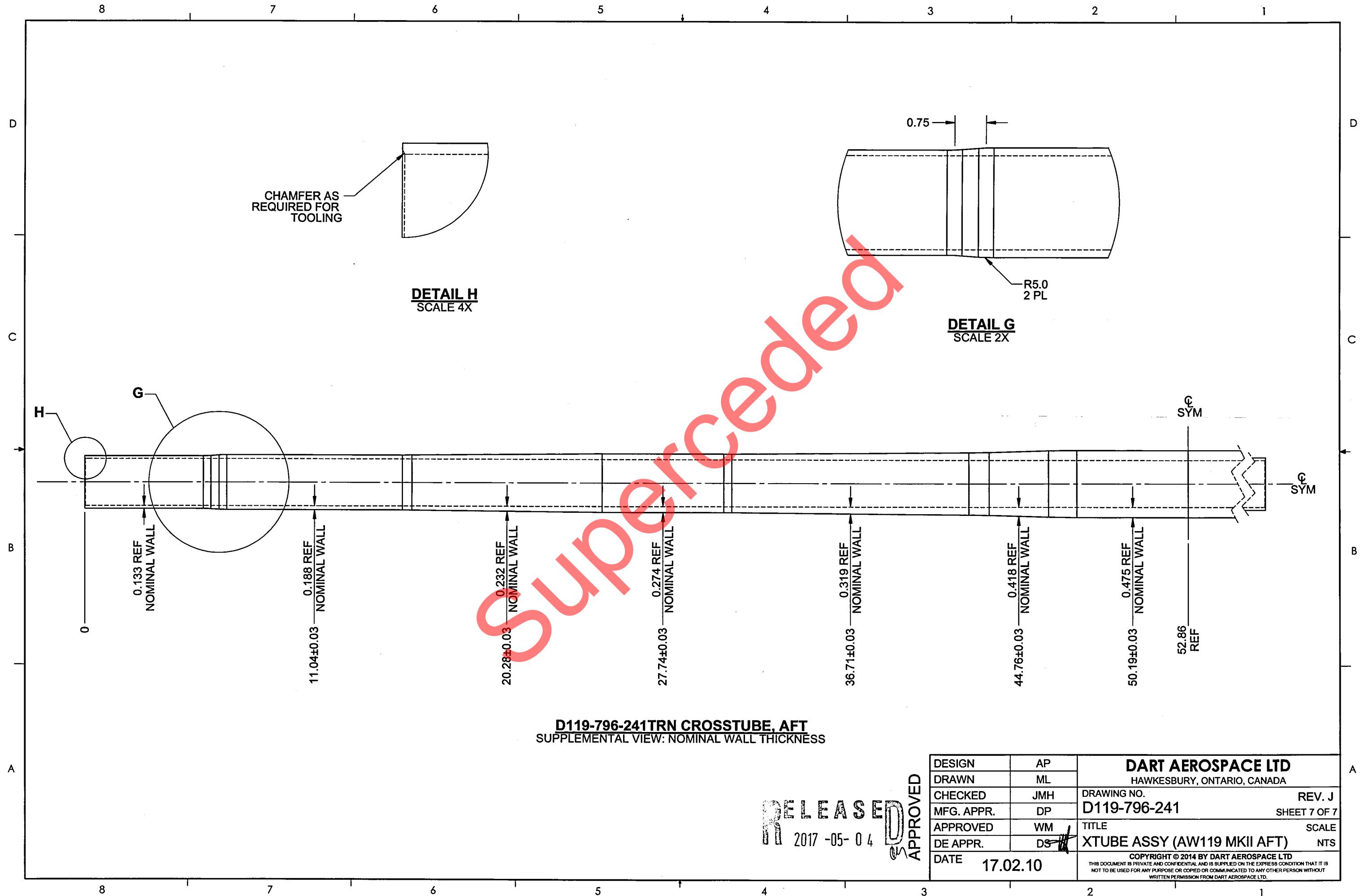
NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6023-106 (PREFERED) OR D6009-106
FINISHED LENGTH = 105.71 ± 0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 24.17 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

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